



ASAP



Work Order ID 62349

Tuesday, September 28, 2010 9:18:54 AM

Page 1

Item ID:	D3313-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Bracket				Stop	
Start Date:	9/28/2010	Start Qty:	200	Cust Item ID:		
Required Date:	10/4/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>MP</u>	Date:	<u>10-4-28</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

10-4-28

3

10-4-28

P10

W/O: 62349		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/09/23	# 120	Took Qty +1 For a inspection template	S	10/09/23	1		S 10/09/23

Part No: D3313-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3313-1

Accept

Revision ID:

Item Name: Mounting Bracket

Start Date: 9/28/2010 Start Qty: 1.00

Required Date: 10/4/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sp 10/07/08

(24)

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

Sp 10/09/09

(4)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sp 10/07/08

(24)

W/O:		WORK ORDER CHANGES					
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Item ID: D3313-1

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Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 9/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

10-9-29



HandFinish

Memo

0.00

Hand Finishing

(4) 0

160

10-9-29 White Gloss (Ref: 4.3.5.1) per QSI005 4.3 Alum

0.00

10-9-29



Powdercoat

Black Sandtex

Memo

M112588

0.00

START. 10:35

Powder Coating

COAT. 3200

FINISH. 11:05

(4) 0

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

=> M 10/09/29

Quality Control

4 0

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Setup Start



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Stop



Item Name: Mounting Bracket

Start Date: 9/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 40

0.00



Packaging

Memo

0.00

Packaging

10/9/29 sf (40)

190

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

10/09/30 sfmf
10-9-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 62349



Parent Item: D3313-1



Parent Item Name: Mounting Bracket

Start Date: 9/28/2010

Required Date: 10/4/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.09.24 PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	82.5840	0.14	0.14		3	



BS10-9-29

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT21

82.584

113608

82.584

113608

②

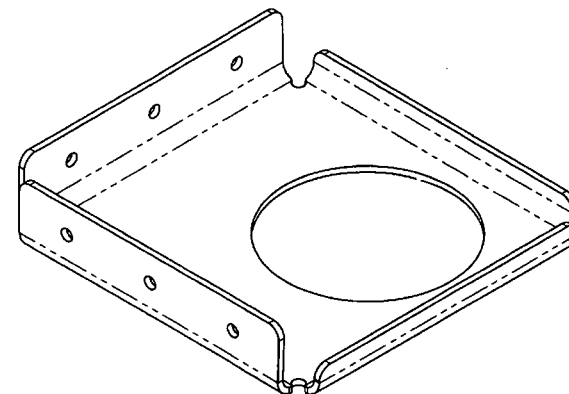
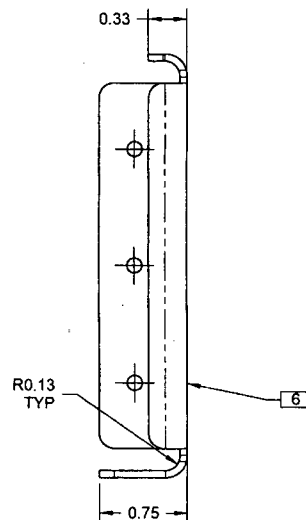
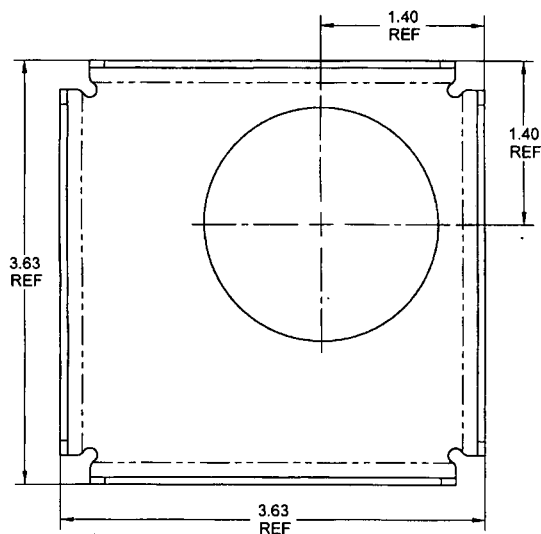
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#62344

D3313-1 MOUNTING BRACKET
MADE FROM D3313-1F

RELEASED
29/07/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3313-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

A	NEW ISSUE		09.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3313	REV. A SHEET 1 OF 2
TITLE MOUNTING BRACKET	SCALE NTS
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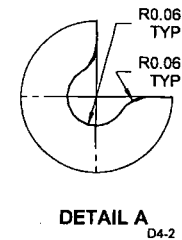
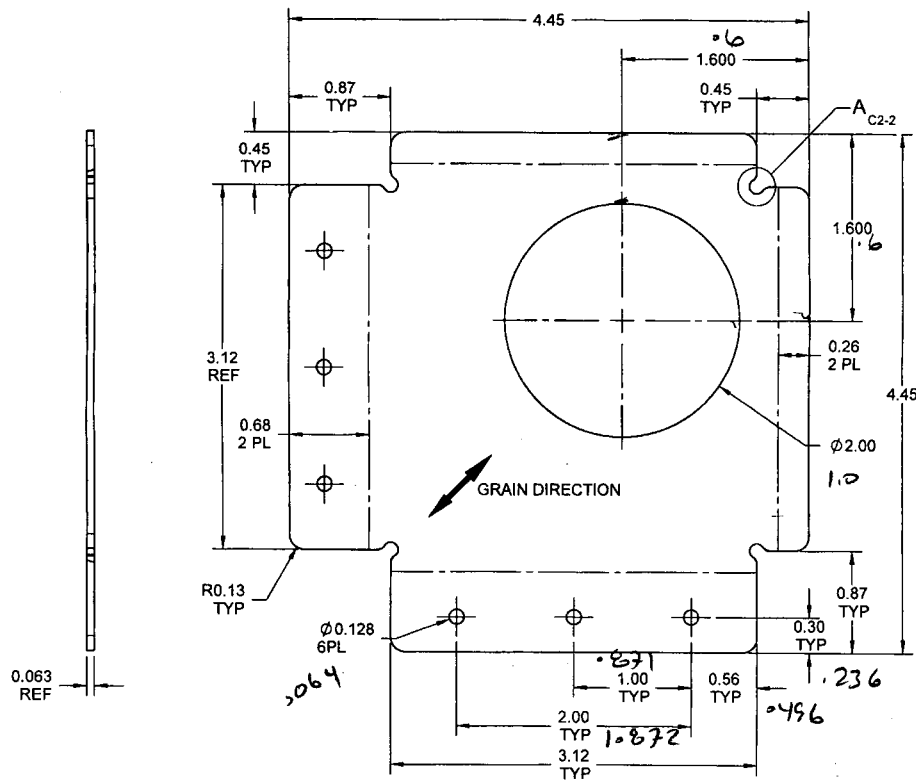
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#62349

D3313-1F MOUNTING BRACKET - FLAT PATTERN

RELEASED
09/03/03

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPC M6061T6S.063)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3313	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING BRACKET	NTS
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